

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 74.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009442**Date Inspected:** 14-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 815**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1715**Contractor:** Goodwin Steel, UK**Location:** Stoke-on-Trent, UK**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** Cable Band**Summary of Items Observed:**

The following report is based on METS observations at Goodwin Steel Castings, Stoke-on-Trent, UK on this date.

The QA inspector witnessed Steve Whitehead welding Casting GG29441-2 B10-2-F. He was observed welding locations 4 and 5 from the approved Weld Excavation Map. He was using welding power supply serial number 7410045568. The weld was being made using 108-119 amps with 3.32 mm E7018-1 SMAW electrode. The QA inspector observed Mr. Whitehead verifying the preheat using an infrared thermometer. The preheat was 205 degrees C.

The QA inspector observed , Goodwin Steel Castings NDT Level II technician Mr. Alan Banks perform Magnetic Particle testing (MT) of Cable Band casting GG29418-6, B2-1-M (initial). The MT was performed in accordance with ASTM standard E709 and Goodwin Steel Castings Magnetic Particle Procedure for Cable Band Castings MT06-09-02 revision 4, using the prod method with leach magnet contacts. Wet florescent magnetic particles were utilized. The direct current magnetizing current appeared to be approximately 1,200 amps. All relevant indications were marked by Mr. Banks. These indications were evaluated by Mr. Banks in accordance with ASTM E125 and Goodwin Steel Castings Magnetic Particle Procedure for Cable Band Castings, MT06-09-02 revision 4. Indications found to be rejectable in accordance with MT-06-09-02 were marked for excavation and reported. The testing was completed on this date and the Quality Assurance Inspector did concur with Mr. Bank's inspection results.

Two castings were observed in fettling. They are under preheat for removal the the risers and runners. The castings are both B8-1-M castings and are identified as GG29432-7, and GG29432-9.

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Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Riegler,Randy
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Quality Assurance Inspector

Reviewed By:	Lanz,Joe
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QA Reviewer
